



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
Fax 613 632-5246

RB T103347-101-103

Job Sheet 195056



Part No: RB T103347-101-103

Job Qty: 3 pcs

Part Name: Support Assembly



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 5/13/19

Job Tracking No:

Due Date: 6/21/19

Created By: Marie Lajeunesse

Type: SOLD

Description:

Note: BWG RB T103347-101 Rev 2 IPP Rev. A 19.05.07 New issue DP Verify DD

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
100	Large Fab - Welded Assy-1	3 pcs	6/21/19		0.25	1.50	Large Fab - 1		
							Large Fab - 10		
							Large Fab - 2		
							Large Fab - 3		
							Large Fab - 4		
							Large Fab - 5		
							Large Fab - 6		
							Large Fab - 7		
							Large Fab - 8		
110	QC 9	3 pcs	6/21/19		0.00	0.00	Large Fab - 9		JUL 24 2019
							QC 9 - 10		
							QC 9 - 18	DAS	
							QC 9 - 24	24	
							QC 9 - 43	9-89	
120	QC 5	3 pcs	6/21/19		0.00	0.00	QC 9 - 50		JUL 24 2019
							QC 9 - 9		
							QC 5 - 10		
							QC 5 - 12		
							QC 5 - 17		
							QC 5 - 18		
							QC 5 - 19		
							QC 5 - 22	DAS	
							QC 5 - 24	24	
							QC 5 - 3	9-89	
							QC 5 - 43		
							QC 5 - 49		
							QC 5 - 51		
							QC 5 - 58		
							QC 5 - 68		
							QC 5 - 9		
							QC 5 - 50		



Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
CANADA
TEL.: 1 613 632-5200
Email: sales@dartaero.com
www.dartaerospace.com

Container No: S200012



Part: RB T103347-101-103

Job No: 195056

Serial No/Batch: S200012

Revision: 2

Inspector:

Exp Date:

Instructions:

Date: 07/24/19

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130 HAAS 4 Axis - B4B	3 pcs	6/21/19	0.00 1.50	QC 5 - 30	
				QC 5 - 40	
				HAAS - 1 - B4B	3C-L 19-07-24
				HAAS - 2 - B4B	
				HAAS - 3 - B4B	
140 QC 2	3 pcs	6/21/19	0.00 0.00	HAAS - 4 - B4B	
				QC 2 - 1	
				QC 2 - 12	
				QC 2 - 14	
				QC 2 - 17	
				QC 2 - 19	
				QC 2 - 2	
				QC 2 - 20	
				QC 2 - 22	
				QC 2 - 23	
				QC 2 - 25	
				QC 2 - 32	3C-L 19-07-24
				QC 2 - 33	
				QC 2 - 35	
				QC 2 - 39	
				QC 2 - 4	
				QC 2 - 40	
				QC 2 - 44	
				QC 2 - 45	
				QC 2 - 48	
				QC 2 - 49	
				QC 2 - 50	
				QC 2 - 51	
				QC 2 - 52	
				QC 2 - 57	
				QC 2 - 62	
				QC 2 - 63	
				QC 2 - 8	
				QC 2 - 66	
				QC 2 - 64	
				QC 2 - 65	
				QC 2 - 5	
				QC 2 - 71	
150 QC 8	3 pcs	6/21/19	0.00 0.00	QC 8 - 12	
				QC 8 - 14	3C-L 19/07/26
				QC 8 - 17	
				QC 8 - 20	
				QC 8 - 25	
				QC 8 - 3	
				QC 8 - 32	
				QC 8 - 33	
				QC 8 - 35	
				QC 8 - 39	
				QC 8 - 4	
				QC 8 - 44	
				QC 8 - 45	
				QC 8 - 49	
				QC 8 - 58	
				QC 8 - 8	
				QC 8 - 9	
				QC 8 - 68	
				QC 8 - 67	
				QC 8 - 1 (A)	
				QC 8 - 47	

https://www.plexonline.com/f5db7783-ead8-49f0-9dff-1aace68cec3f/Plexus_Control/Report_View_2.asp?URL=../Part/Job_Sheet.asp&Report=True&... 3/4

				Packaging 3 - 16 - B4B	
				Packaging 3 - 17 - B4B	
				Packaging 3 - 18 - B4B	
				Packaging 3 - 19 - B4B	
				Packaging 3 - 20 - B4B	
				Packaging 3 - 21 - B4B	
				Packaging 3 - 22 - B4B	
				Packaging 3 - 23 - B4B	
				Packaging 3 - 24 - B4B	
				Packaging 3 - 25 - B4B	
				Packaging 3 - 26 - B4B	
				Packaging 3 - 27 - B4B	
				Packaging 3 - 28 - B4B	
				Packaging 3 - 29 - B4B	
				Packaging 3 - 30 - B4B	
				Packaging 3 - 31 - B4B	
				Packaging 3 - 32 - B4B	
				Packaging 3 - 33 - B4B	
				Packaging 3 - 34 - B4B	
				Packaging 3 - 35 - B4B	
				Packaging 3 - 36 - B4B	
200 QC 21 - SA	3 pcs	6/21/19	0.00 0.00	QC 21 - SA - 21	Das 21
				QC 21 - SA - 70	9-se JUL 3 1 2019
				QC 21 - SA - 53	

Part Op 100 - (Fabricate per Drwg) Weld as per drawing.
 Descriptions: 110 - (QC9- Inspect visual per QSI004- Fusion Welds)
 130 - 1-Machine as per folio FC N/A FOLIO REV: N/A DWG REV: 2 Face and drill
 holes 2-Debur
 160 - Issue P/O: 44132 -ANODIZE COLOR CLEAR, PER IAW MIL-A-8625F TYPE 2 CLASS 1, Water sealant -
 Material type; 6061T6 -Certificate of Conformity is required
 170 - (Receive & Inspect for Damage & Mat'l Certs)
 180 - (QC6- All purchased or subcontracted products)
 190 - (Identify as per dwg & Stock Location: _____)
 200 - (QC21- Final Inspection - Work Order Release)

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
RB T103347-101-119	Base	3 pcs (1 ea)	100-Large Fab - Welded Assy-1	3187690
RB T103347-101-121	Arm	3 pcs (1 ea)	100-Large Fab - Welded Assy-1	5187666
RB T103347-101-123	Arm	3 pcs (1 ea)	100-Large Fab - Welded Assy-1	5187683
RB T103347-101-125	Arm	3 pcs (1 ea)	100-Large Fab - Welded Assy-1	5187657
RB T103347-101-127	Head	3 pcs (1 ea)	100-Large Fab - Welded Assy-1	5186447

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
100-Large Fab - Welded Assy-1	RB T103347-101-119	3	0	0
	RB T103347-101-121	3	0	0
	RB T103347-101-123	3	0	0
	RB T103347-101-125	3	0	0
	RB T103347-101-127	3	0	0

Part Specifications

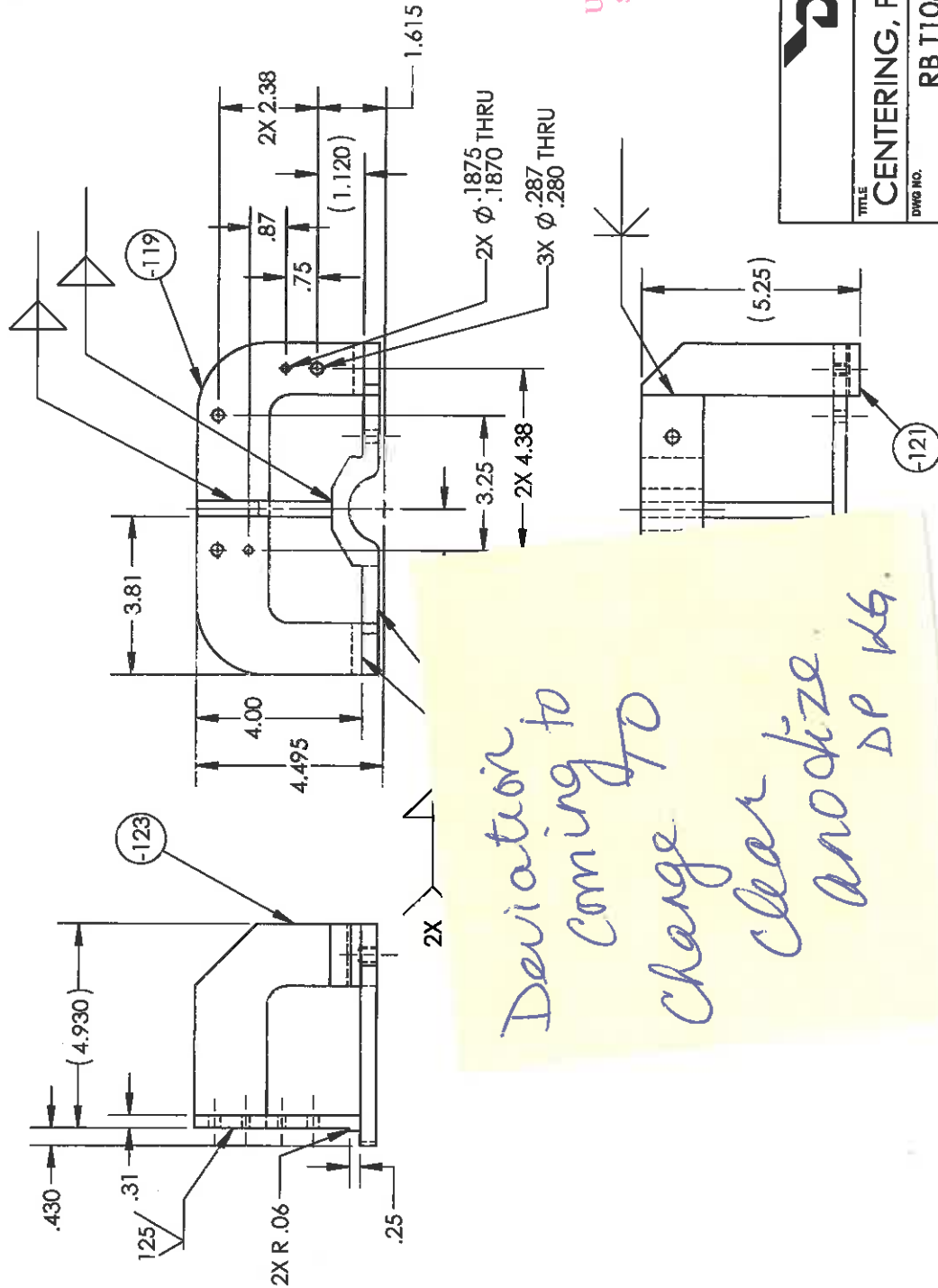
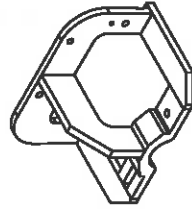
Specifications could not be found.

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REVISIONS

REV	ECR	DESCRIPTION	DATE	INITIAL	APPROVED
2	15-0197	-103 ADDED DIM (5.25)	8/5/2015	RJC	JAG



Deviation to
coming to
change
clear
anodize
DP VG.

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 195056 M5
1925-13



TITLE
CENTERING, PILOTS CYCLIC STICK

DWG NO. RB T103347-101-103

REV 2

DRAWN BY: DUERFELDT	APPROVED: D. Muel
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES	FINISH: BELL 412
.XXX $\pm$.010	TREAT: CHEM FILM
.XX $\pm$.03	CLASS 1A
.X $\pm$.1	USED ON MODEL
1. BREAK ALL SHARP EDGES .015 x 45°	BELL 412
2. DIMENSIONAL LIMITS APPLY AFTER PLATING	
SCALE 1:4	DATE 6/12/2014
	SHEET 2 OF 9

-103

SUPPORT ASSEMBLY

Entered: _____

Date: _____

WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

NCR No. _____

Route update only ☐

Job: _____		DISPOSITION				DEPARTMENT/PROCESS													
Part No. _____		Rework ☐ Scrap ☐ Use-as-is ☐				Skid-tube ☐ Machining ☐ Large Fab ☐		Cross tube ☐ Small Fab ☐ Finishing ☐		Eng. (Non-AW) ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐		Engineering ☐ Water Jet ☐ Supplier ☐ Quality ☐							
Date: _____	Sequence #: _____	QTY Affected: _____		MRB (QS042)															
Description Work Order Deviation				Disposition															
														Completed By					
														Lead hand / Supervisor					
														QC / QA Coordinator					
Root Cause				FAULT CATEGORY															
Operator ☐ Manufacturing Process ☐ Equip/Tooling ☐ Handling/Preservation ☐ Material ☐ Product Improvement ☐ Process Improvement ☐ Human Factors ☐				Pressure/Forced ☐ Bending ☐ Crushing ☐ Cracks ☐ Crimp/Kink/Ripple/Wave/Twist ☐ Marks/Chatter ☐ Mislabeled ☐				Contamination ☐ Misaligned/off center ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Incomplete/Unclear Instructions ☐ Drill Holes ☐ Fit/Function ☐				Power Loss/Surge ☐ Folio/Program ☐ Grain Direction ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set/Set-up ☐				Positioned Wrong ☐ Outside Tolerance ☐ Drawing ☐ Finish ☐ Part Lost/Missing ☐ Misread ☐			
				Other/Details: _____															



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PURCHASE ORDER

POHB044132



Supplier: ATG001-VC
A.T.G. Industries Inc
731 INDUSTRIELLE ROAD
ROCKLAND
ON
K4K 1T2 Canada
Phone: 613-446-4544
Fax: 613-446-4556

Attention: Lalande, Marc-Andre

Ship To: 1270 Aberdeen Street
Hawkesbury
ON
K6A 1K7 Canada
Phone: 613-632-5200

PO No: POHB044132
PO Date: 7/29/19
Due Date: 8/2/19
Purchase Order
Revision:
Revision Date:
Ship-To Contact: Phone:

Via: Ground
Pymt Terms: Net 30
Freight Terms:
Special Comments:

E-MAILED
009-07-30

Items

Line Item	Job	Part	Description	Status	Account	Due Date	Order Quantity	Received Quantity	Balance	Unit Price (CAD)	Extended Price
1	196725	RB6795969-3	Shank -Issue P/O; -ANODIZE COLOR RED, PER IAW MIL-A- 8625 TYPE-2 CLASS-2, Water sealant -Material type; 6061T6 -Certificate of Conformity is required	Firmed	-	8/2/19	4 pcs	0 pcs	4 pcs	\$18.46/pcs	\$73.84
2	197043	649.5110	Wiper Deflector : Various STC's (Outsource process-Anodize per QSI017 4.1.10.1) Outsource process-Anodize per QSI017 4.1.10.1 Issue P/O to ATG 1- Black Anodize as per Dwg 649.5100 2- PRIME AS PER DWG, SEE NOTE #2 Certification of Conformity is required	Firmed	-	8/2/19	16 pcs	0 pcs	16 pcs	\$10.35/pcs	\$165.60

4 X JUL 30 2019

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PURCHASE ORDER

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Items											
Line Item	Job	Part	Description	Status	Account	Due Date	Order Quantity	Received Quantity	Balance	Unit Price (CAD)	Extended Price
3	192401	D4822-1	Upper Deflector, LH : Various STC's HARD ANODIZE IAW MIL-A-8625 TYPE 3 COLOUR BLACK PRIME AS PER DWG D4821 REV. B	Firmed	-	8/2/19	8 pcs	0 pcs	8 pcs	\$31.80/pcs	\$254.40
4	197040	649.5011	Deflector : Various STC's (Outsource process-Anodize per QSI017 4.1.10.1) Issue P/O to ATG: AS PER MPP- 172 SECTION 2.1, HARD ANODIZE COLOR BLACK, PER IAW MIL-A- 8625 TYPE 3 CLASS 2 AS PER MPP-172 SECTION 4.2, PRIME AS PER IAW MIL-PRF- 23377 TYPE 1 CLASS N Certification of Conformity is required	Firmed	-	8/2/19	10 pcs	0 pcs	10 pcs	\$12.30/pcs	\$123.00
5	197041	649.5012	Deflector : Various STC's Issue P/O to ATG: AS PER MPP- 172 SECTION 2.1, HARD ANODIZE COLOR BLACK, PER IAW MIL-A- 8625 TYPE 3 CLASS 2 AS PER MPP-172 SECTION 4.2, PRIME AS PER IAW MIL-PRF- 23377 TYPE 1 CLASS N Certification of Conformity is required	Firmed	-	8/2/19	20 pcs	0 pcs	20 pcs	\$9.10/pcs	\$182.00



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PURCHASE ORDER

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Items											
Line Item	Job	Part	Description	Status	Account	Due Date	Order Quantity	Received Quantity	Balance	Unit Price (CAD)	Extended Price
6	197048	649.5113	Wiper Deflector Shlm : Various STC's - Issue P/O to ATG : - Hard Anodize Black, Type 3, Class 2 as per Dwg. - Prime as per Dwg. Certification of Conformity is required.	Firmed	-	8/2/19	20 pcs	0 pcs	20 pcs	\$8.05/pcs	\$161.00
7	195056	RB T103347-101-103	Support Assembly -Issue P/O; -ANODIZE COLOR CLEAR, PER IAW MIL-A-8625F TYPE 2 CLASS 1, Water sealant -Material type; 6061T6 -Certificate of Conformity is required	Firmed	-	8/2/19	3 pcs	0 pcs	3 pcs	\$18.46/pcs	\$55.38
Line Item Note **this piece is require RUSH**											
	198386			Firmed	-	8/2/19	2 pcs	0 pcs	2 pcs	\$18.46/pcs	\$36.92
Sub Total:							5	0	5		\$92.30
Grand Total:										\$1,052.14	

DAS
40
9-89

3x JUL 30 2019



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PURCHASE ORDER

POHB044132



Order Notes

Procurement Quality Clauses

A005 right of entry
A012 chemical and physical test report
A016 personnel qualification
A017 raw material identification (as applicable)

A022 Apical Processing
A024 process certifications
A026 certification of material conformance

A041 quality management system
A042 dart notification by supplier
A043 retention of quality documents

A048 counterfeit parts avoidance, detection, mitigation and disposition program

A049 supplier awareness

Terms & Condition of Purchasing(Suppliers) and Procurement Quality Clauses are an integral part of our AS9100 requirements. To learn in detail, please visit www.dartaerospace.com for further explanation.

Plex 7/30/19 2:35 PM Dart.Guerin.Kimberley



A.T.G. Industries Inc.
760 Industrielle Street
Rockland, ON K4K 1T2
Canada

Ph: (613) 446-4544

Fax: (613) 446-4556

Pack List

Number: 918319

Date: 30-Jul-19

To

Dart Aerospace Ltd
1270 Aberdeen St
Hawkesbury, ON K6A 1K7

Ship To

Patrick Lussier
Dart Aerospace Ltd
1270 Aberdeen St
Hawkesbury, ON K6A 1K7

Ph: 613 632-9577

Fax: 613 632-1053

Ph: 613 632-9577

Fax: 613 632-1053

Terms		Ship Via	
		ATG Delivery	
Quantity	Description		
	Please reference this document's Pack List number on all correspondences regarding this shipment. If you have any questions, please contact us.		
4 ea	Part: RB6795969-3 Shank Hard Anodize per MIL-A-8629F, Type II, Class 2, Red, Water Sealant Job: 25667 PO: POHB044132	Rev:	
5 ea	Part: RB T103347-101-103 Support Assembly Anodize per MIL-A-8625F, Type II, Class 1, Clear, .0004-.0010" (.4 - 1 mils), Water Sealant Job: 25673 PO: POHB044132	Rev:	DAS 40 9-89
CERTIFICATE OF CONFORMANCE A.T.G Industries Inc. certifies that all items in this shipment conform to the requirements. Date: JUL 30 2019 Certified Signature: _____ Receiver Signature: _____ A.T.G Industries Inc. is AS9100 Registered and Nadcap Chemical Processing Accredited. Note: This Packing Slip may contain parts that have been PLATED. Items that are plated may be subject to natural tarnishing and it is suggested that they be inspected within 24 hours of receipt.			
Made in Canada.			

RECEIVED

JUL 30 2019

DART AEROSPACE LTD.